

Date: Thursday, 25/10/2007 2:34:50 PM  
User: Linda Lacelle

# Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : OUTSIDE WASHER  
Job Number : 35399  
Estimate Number : 11154 Part Number : D32335  
P.O. Number : N/A Drawing Number : D3233 REV B  
This Issue : 25/10/2007 S.O. No. : N/A Project Number : N/A  
Prsht Rev. : NC Drawing Revision : B  
First Issue : N/A Type : MACHINED PARTS Material : N/A  
Previous Run : 28620 Due Date : 01/11/2007 Qty: 14 Um: Eac  
Written By :  
Checked & Approved By :  
Comment : Est. A 05.03.14 New issue KJ/JLM

## Additional Product

Job Number:



Seq. #: Machine Or Operation:

Description :

1.0

M1020TR1875W250

COLD DRAWN ROUND TUBE



Comment: Qty.: 0.1860 f(s)/Unit Total : 2.6034 f(s)

1020-1025 Round Tube

Material: AISI 1020-1025 Seamless Round Tubing Cold Drawn per MIL-T-5066 or ASTM A513-00 MT1020

SRA or AMS 5075 or AMS 5077

(M1020TR1.875W.250)

Identify for D3233-5

Batch: M102210

071026

2.0

LATHE CONV.

CONVENTIONAL LATHE



Comment: CONV.LATHE

Turn as per Dwg D3233

INSPECT PARTS AS THEY COME OFF MACHINE

3.0

QC2



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

071026

4.0

MILLING CONV.

CONVENTIONAL MILLING MACHINE



Comment: CONVENTIONAL MILLING MACHINE

1- Mill as per dwg D3233

2-Deburr

INSPECT WORK TO CURRENT STEP

5.0

QC5



Comment: INSPECT WORK TO CURRENT STEP

071029

counted

## Process Sheet

Customer: CU-DAR001 Dan Helicopters Services

Drawing Name: OUTSIDE WASHER

Job Number: 35399

Part Number: D32335

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *W523*

*CALL*

*Cpl 07-10-29*

*(4)*

7.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

*(4)*  
*Final 10/27*

Job Completion

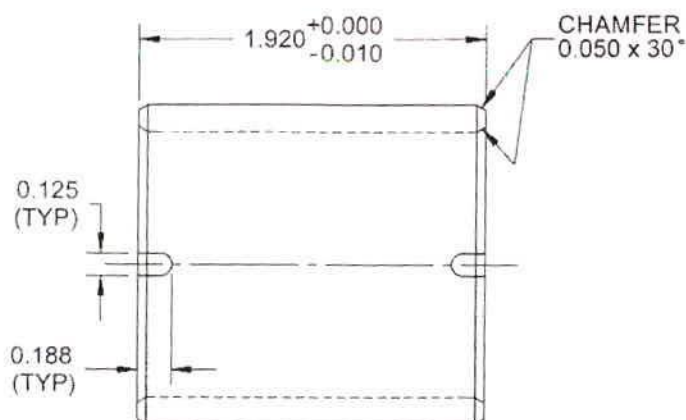


*U 07-10-29*

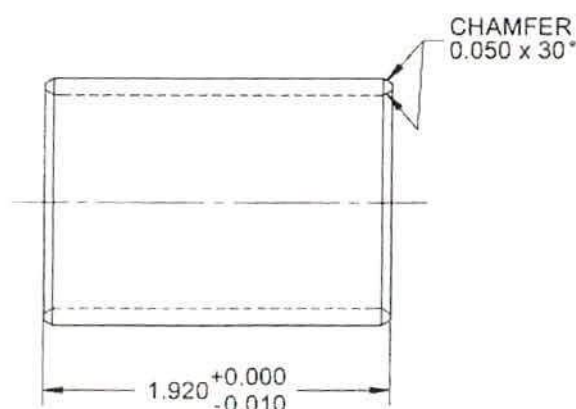
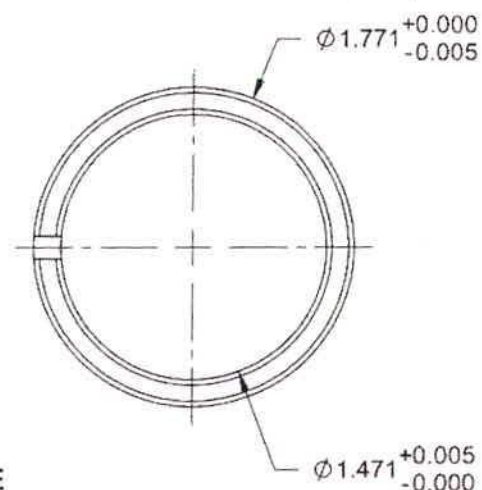


DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>FT</i>	APPROVED <i>WBS</i>	DRAWING NO. D3233	REV. B SHEET 3 OF 3
DATE 05.03.08	TITLE WHEEL ASSEMBLY		SCALE 1:1

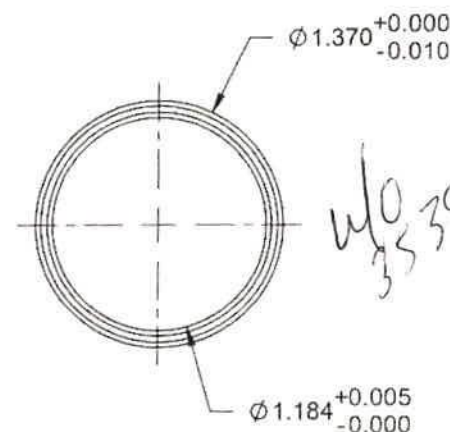
RELEASED  
*WBS*  
05/05/09



**D3233-5 HUB SLEEVE**



**D3233-7 SHAFT SLEEVE**



**NOTES:**

- 1) MATERIAL: AISI 1020-1025 ROUND TUBING PER MIL-T-5066 OR ASTM A513-00 MT1020 SRA OR AMS 5075 OR AMS 5077, COLD DRAWN, SEAMLESS (REF. DART SPEC. M1020TR)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.010 TO 0.030

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